

Date: Wednesday, 2/15/2006 3:46:44 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number	: 25843	Part Number	: D29331
Estimate Number	: 10833	Drawing Number	: D2933 REV B.
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/15/2006 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 3/10/2006
Previous Run	: 25376	Qty:	4 Umi: Each
Written By	: _____		
Checked & Approved By	: _____		
Comment	: Est: B00.06.26 New DWG rev (mpp 2069) EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6101001

7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Issue material from stock: 7075-T7351 QQA-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No:

24890 => 3 parts

23734 => 1 part.

SD

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

SD 06.04.23

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SD 06.04.23

4.0

QC1

INSPECT ALL DIM TO DIM SHEET




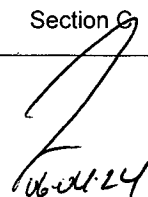
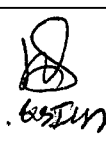
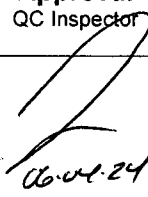
Comment: INSPECT ALL DIM TO DIM SHEET

SD 06.04.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-06-24	2	- 1 part made with grain on wrong direction (bad billets batch) B23934		Scrap, destroy & replace scrap - ensure grain on billets is good. No replace. Set-up removed. Scrap all. can not determine which one	SD 06-04-24	 06-04-24		 06-04-24

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 25843

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W. D. 02.02.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25843
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B		Page 1 of 1

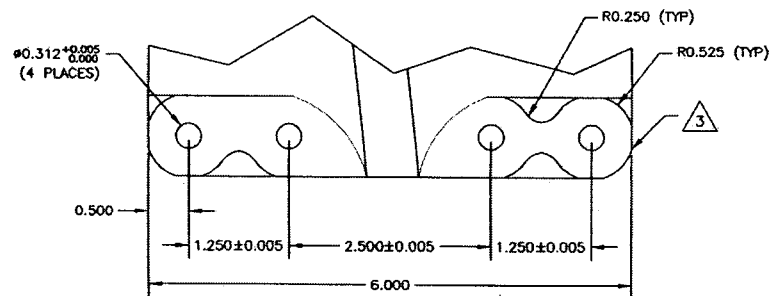
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.125	.126	.124		
B	0.100	0.140		.125	.125	.126	.124		
C	0.100	0.140		.120	.120	.120	.120		
D	0.210	0.230		.229	.223	.222	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515							
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.498	2.498	2.498	2.498		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240							
N	0.100	0.140		.124	.123	.123	.122		
O	0.540	0.560		.549	.548	.549	.547		
P	0.490	0.510		.502	.501	.501	.499		
Q	3.715	3.725		3.722	3.722	3.722	3.722		
R	2.470	2.510		2.498	2.498	2.498	2.498		
S	0.240	0.270		.263	.260	.255	.255		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.629	1.629	1.629	1.629		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.125	1.145		1.132	1.130	1.133	1.133		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	06.04.23

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

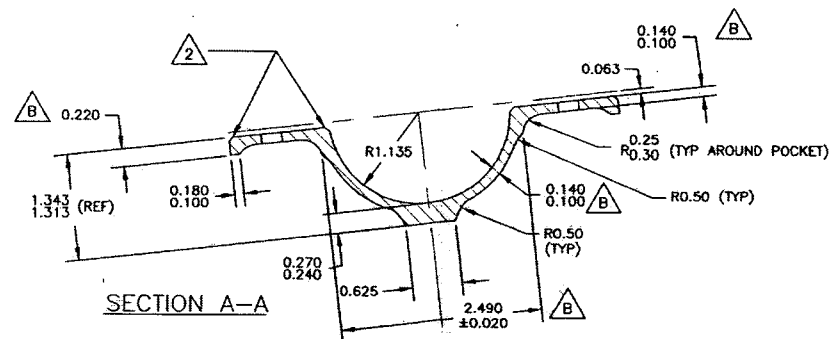
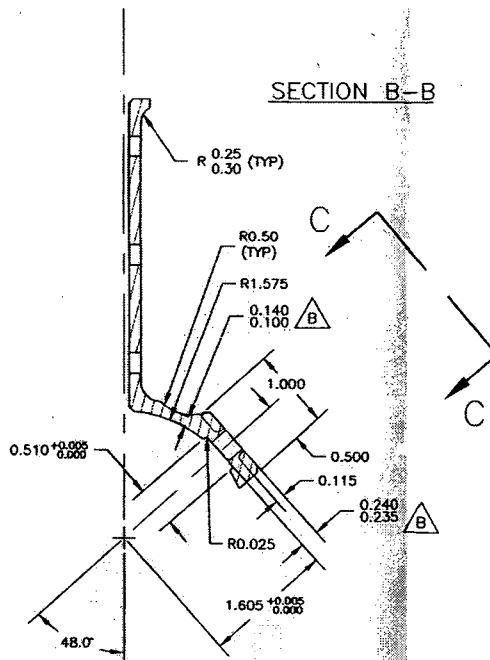


VIEW C-C

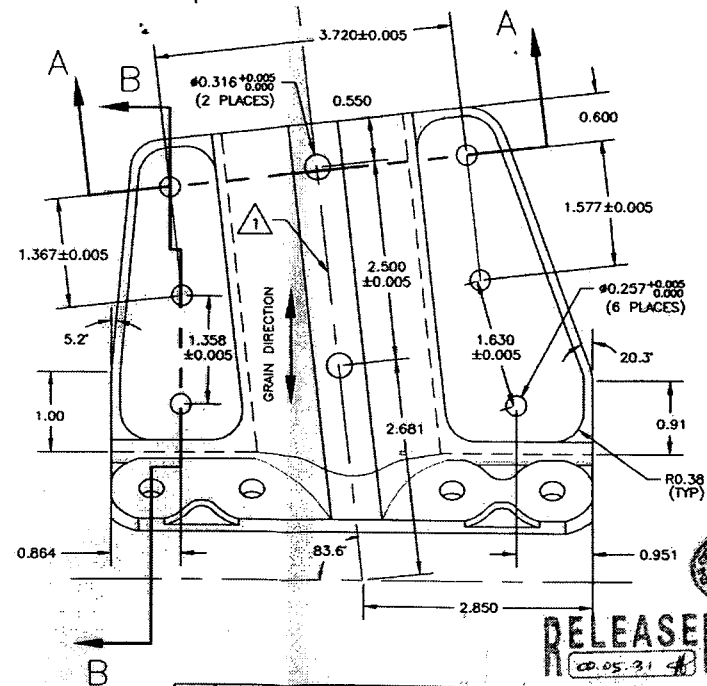
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005.4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART OSI 005.4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



SECTION A-A



RELEASED
00.05.31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE	00.05.29	TITLE SADDLE INSIDE
		REV. B SHEET 1 OF 1 SCALE 2:3

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NO. 25843

Linda Lacelle

From: Linda Lacelle [llacelle@dartaero.com]
Sent: Monday, April 24, 2006 11:25 AM
To: Carreiro, Mario - copp/bras (E-mail)
Subject: p.o 2008787

Hi Mario,
Just to let you know the billets D6101-001 on P.o 2008787- rec'd on Dec 30th,- the grain direction was on the wrong side.
We will use anyway, as these are abit oversized.
Thx
Linda